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D205-596-105
Job Sheet 193114



Part No: D205-596-105

Job Qty: 1 pcs

Part Name: Fwd Crosstube - Extended Height 31"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 4/30/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D205-596-105 REV.C IPP Rev:D 05.03.21 Added bending procedure KJ/JLM IPP Rev:E 08-01-10 ECN 1075 DD IPP Rev F 08.04.28 Added bending & mat'l EC verified by: DD IPP rev G 10.05.27 chg QC15 to QC6 EC verified by: DD IPP REV:H 13.11.29 as per dwg DEO B-2 DD VERF:JLM IPP REV:I 18.02.08 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
105	Crosstubes - 1	1 pcs	4/30/19		0.00	0.00	Crosstubes - 1		GP 19-04-12
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		
107	QC 7	1 pcs	4/30/19		0.00	0.00	QC 7 - 10		DAS APR 12 2019 68 9-89
							QC 7 - 13		
							QC 7 - 14		
							QC 7 - 15		
							QC 7 - 17		
							QC 7 - 18		
							QC 7 - 19		
							QC 7 - 2		
							QC 7 - 28		
							QC 7 - 3		
							QC 7 - 30		
							QC 7 - 34		
							QC 7 - 36		
							QC 7 - 37		
							QC 7 - 41		
							QC 7 - 47		
							QC 7 - 48		
							QC 7 - 51		
							QC 7 - 58		
							QC 7 - 59		
							QC 7 - 60		
							QC 7 - 9		
							QC 7 - 68		
							QC 7 - 50		
							QC 7 - 67		



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Container No: S172004



Part: D205-596-105

Job No: 193114

Serial No/Batch: S172004

Revision: C

Inspector:

Exp Date:

Instructions: TC STC SH03-6 Issue 4, FAA STC SR01742NY 13/11/04, EASA ST

				QC 7 - 40	
110	Crosstubes - Bend - 2 - B4B	1 pcs	4/30/19	0.00 0.39	Crosstubes - Bend - B4B
130	QC 15	1 pcs	4/30/19	0.00 0.00	QC 15 - 12
					QC 15 - 3
					QC 15 - 47
					QC 15 - 49
					QC 15 - 58
					QC 15 - 9
140	Crosstubes - 2 - B4B	1 pcs	4/30/19	0.00 0.00	Crosstubes - 1 - B4B
					Crosstubes - 2 - B4B
					Crosstubes - 3 - B4B
					Crosstubes - 4 - B4B
150	Crosstubes - 3 - B4B	1 pcs	4/30/19	0.00 0.00	Crosstubes - 1 - B4B
					Crosstubes - 2 - B4B
					Crosstubes - 3 - B4B
					Crosstubes - 4 - B4B
155	QC 7	1 pcs	4/30/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
160	QC 5	1 pcs	4/30/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40

GP 19-04-18

JW

GP 19-04-23

GP 19-04-23

DAS
APR 24 2019 68
9-89

DAS
APR 24 2019 68
9-89

170	Spray Paint - 2 - B4B	1 pcs	4/30/19	0.00 0.00	Spray Paint - 1 - B4B	• A8 19-4-25
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
180	QC 14	1 pcs	4/30/19	0.00 0.00	QC 14 - 15	DAS APR 29 2019 58 9-89
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
190	Crosstubes - 4 - B4B	1 pcs	4/30/19	0.00 0.00	Crosstubes - 1 - B4B	• A8 19-4-26
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
200	QC 5	1 pcs	4/30/19	0.00 0.00	QC 5 - 10	DAS APR 29 2019 58 9-89
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
210	Packaging 3-1 - Stock - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS 46 9-89 APR 29 2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
215 DC - 1 - B4B	1 pcs	4/30/19	0.00 0.00	DC - 1 - B4B	21 APR 30 2019
				DC - 2 - B4B	9-89
220 QC 21 - FG	1 pcs	4/30/19	0.00 0.00	QC 21 - FG - 21	DAG APR 30 2019
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-89

Part Op **105** - (Crosstubes Chemical Conversion)INSIDE AND OUT
 Descriptions: **107** - (QC7-Inspect Chemical Conversion Coat)
110 - (CNC Alpha 160 Bender)Bend as per Dwg D2889 using CNC bender program
130 - (QC15- Crosstube Dimensional Check)
140 - (Crosstubes)1-Cut as per Dwg D205-596-105 2-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***
 Deburr & Inspect for surface damage. Polish cut surface.Scribe part # and batch # on one end of tube.
150 - (Crosstubes)***IMMEDIATELY AFTER GRINDING***
155 - (QC7-Inspect Chemical Conversion Coat)
160 - (QC5- Inspect part completeness to step on W/O)
170 - (Spray Paint / NDT Room)*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside and
 outside as per dwg and per QSI 005 4.1 Batch: 5143304 2- Paint outside per QSI 005 4.2
 Batch: 5166819
180 - (QC14- Inspect Spray Paint)
190 - (Crosstubes)1- Lightly scuff the bonded area using a 180 grit sand paper and clean the area with 41058 wash 'n'
 wipe 2- Apply Proseal as per dwg D205-596-105. 3- Install clamps as per dwg (Note 12)Torque clamps 80 to 100 in-lb as
 per dwg and Note 13) 5146134 exp 10/19
200 - (QC5- Inspect part completeness to step on W/O)***PRIOR TO PACKAGING RECHECK TORQUE ON CLAMPS
 AFTER PROSEAL HAS CURED 72HOURS.***
210 - (Identify as per dwg & Stock Location:)Identify and pack for shipping as per PPP D205-596-105
215 - (Document Control)Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG003
220 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6005-180	Crosstube Material	1 Ea (1 ea)	105-Crosstubes - 1	
D2893-1	Support	2 pcs (2 ea)	190-Crosstubes - 4 - B4B	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 pcs (4 ea)	190-Crosstubes - 4 - B4B	
MS21920-25	Clamp	4 Ea (4 ea)	190-Crosstubes - 4 - B4B	

Job Allocations

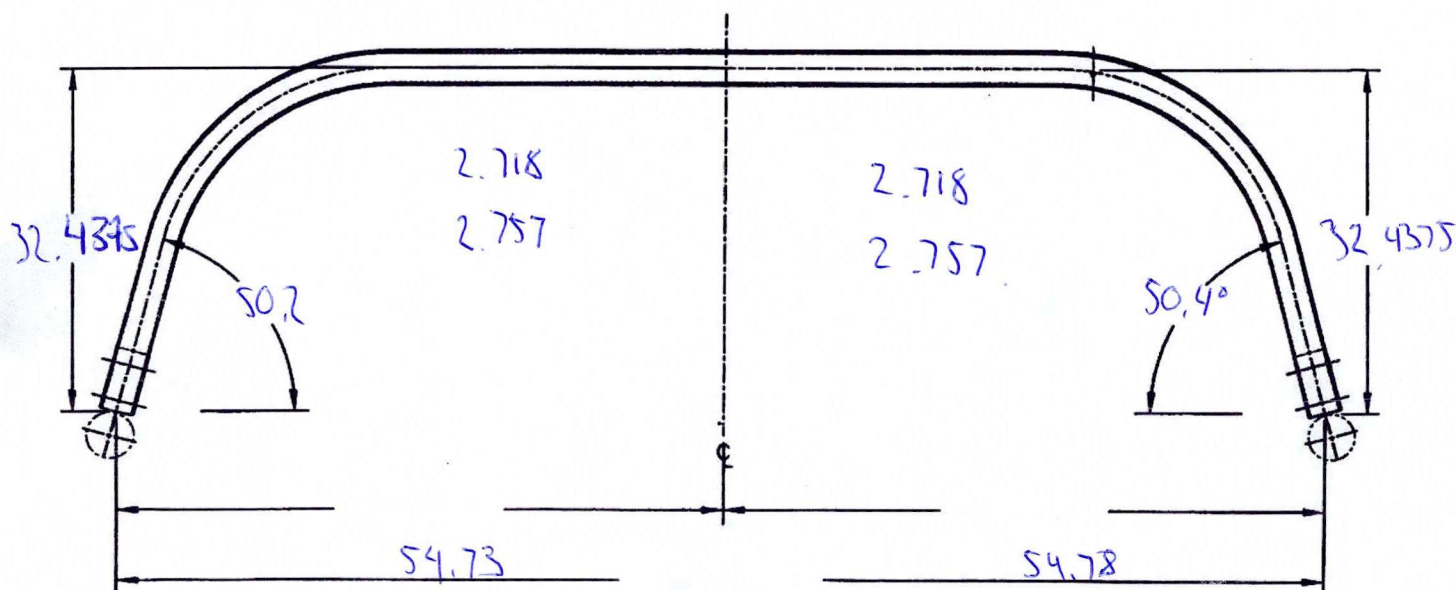
Operation	Component Part	Required	Inventory	Allocated
105-Crosstubes - 1	D6005-180	1	6	0
190-Crosstubes - 4 - B4B	D2893-1 <u>5167970</u>	②	15	0
	D3595-063-450 <u>5167855</u>	④	59	0
	MS21920-25 <u>5142130</u>	④	56	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order:	193/14
Description: Crosstube High-High Fwd		Part Number:	D205-596-105
Inspection Dwg: D205-596-105 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6
Bending Passes	3	--
Crushing	--	6%



	Side A	Side B
Bending Passes	12	12
Crushing	0.7%	0.7%
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	12.04.16	Added bending, crushing dimensions	KJ	
D	18.05.24	Dwg Rev updated	MC	